

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003690**Date Inspected:** 20-Aug-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2200**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 800**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Sherri Brannon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and or discovered the following.

Bay 2 Sub Assembly Shop:

114 Meter Mock-UP- Caltrans QA Inspector observed the 114 Meter Mock-up to be idle during this shift.

Rolling- Caltrans QA observed Inspector no plates were rolled on this date to correct flatness dimensions.

Thermal Cutting- Caltrans QA Inspector observed ZPMC cutting plates for OBG side/bottom panels.

Milling- Caltrans QA Inspector observed ZPMC using the horizontal milling machine to mill beveled edges of various tower web plates.

Bay 8- Sub Assembly Shop - Tower Double Diaphragm

Caltrans QA Inspector observed the tower double diaphragm to be idle during this shift.

NDT Inspection Caltrans QA - Caltrans QA Inspector performed magnetic particle testing (MT) on

ESD1-SA80D/E-3, WJ#3A & 10A tower bay 2, SSD1-SA179B1/E, WJ#1A & 7B tower bay 1 and FB028-001 Far side – Weld joints #'s 71, 72, 77, 86, 87, 88, 93, 106, 107, 114, 111, 120 121, 123, 124, 129, 130, 131, 132, 133, 138, 139, 140, 141, 144, 145, 147 and 148 OBG Bay 7. Caltrans QA Inspector found reject-able indications in weld joint's 139, 141 & 147. QA Inspector informed ZPMC QC Xu Jun. Eric informed QA that he will notify personnel on 1st shift. ZPMC MT technician Mr. Bo Ting had signed off on the above mentioned FB028-001. See Caltrans Magnetic Particle Test Report, TL-6028 dated August 20, 2008 for additional information.

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Summary of Conversations:

No relevant conversations to report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 13816942685, who represents the Office of Structural Materials for your project.

Inspected By:	Brannon, Sherri	Quality Assurance Inspector
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Reviewed By:	Lanz, Joe	QA Reviewer
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